Page 1

Item ID:

D3459-1

9/30/2011

Monday, October 03, 2011 4:00:53 PM

Accept

Setup Start



Stop



Revision ID:

Start Date:

Item Name: Float Step Mounting Plate

Required Date: 10/14/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: M.L. J

Date: 11 10 03 Tooling:

Date:

Date:

Date:

Start Run

Stop



Sequence ID/ Work Center ID Operation

Revision Nbr

Description

Set Up/

Tool ID

Tool# Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Draw Nbr D3459

Rev A

100

Waterjet

FLOW CNC Waterjet

6061.18784'

FLOW WATER JET

Memo

1-Cut as per Dwg D3459

Prog Rev:

0.00

SPC (Y/N):

Run Hours

0.00

Dwg Rev: 2-Deburr if necessary

B1-11-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

QC

Memo

0.00

B1-11-2

120

Memo

QC8- Inspect parts - second check

1 11.07

Quality Control

0.00

0.00

Dart	Aer	ospa	ce	Ltd
- 41 .	~~	COPU	~~	

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
									,
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	.
	R	esolution:						Date: _	
NCR:		\\	WORK ORD	ER NON-CONFORMA	NCE (NCR)			!
DATE	STEP	Description of NC			on B	Verifica			Approval
		Section A	Chief Eng	Chief Eng	Date	Sect	ion C	Chief Eng	QC Inspector
								•	
	,								
1									

Work Order ID 74517

Monday, October 03, 2011 4:00:53 PM



Page 2

Item ID:

D3459-1

Accept

Setup Start

Stop

Stop



Revision ID:

Item Name:

Float Step Mounting Plate

Start Date:

9/30/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

*** STOCK IN STEP CELL***

Tooling:

Date:

Date:

Run Start

Required Date: 10/14/2011

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: WA

0.00

0.00

140

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00 0.00

Quality Control

Dart Aerospace I

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No.		DAD #.	Fault Cata		NOD	N. 504	D			
Part NO					NCR: Yes No DQA: Date: QA: N/C Closed: Date:					
NCR:		· · · · · · · · · · · · · · · · · · ·		ER NON-CONFORMA						
DATE	STEP	Description of NC			on B	Verification	Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
	-									

Picklist Print

Monday, October 03, 2011 4:00:58 PM

Work Order ID: 74517

Parent Item: D3459-1

Parent Item Name: Float Step Mounting Plate

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev: A New Issue 06-01-06 JLM IPP Rev: B Waterjet 06-05-23 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00		Purchased	No		100	f	27.1000	0.347	4.383158	52		

Location	Loc Qty	Loc Code	
MAT001	27.1		
118400	7.1		1180
118844	20		



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-	
Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA :	Date: _	
Resolution:			Dispositi	on:	_ QA: N/C Cld	osed:	Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
I								
		•						

DART AEROSPACE LTD	Work Order:	74517
Description: Float Step Mounting Plate	Part Number:	D3459-1
Inspection Dwg: D3459 Rev: A		Page 1 of 1

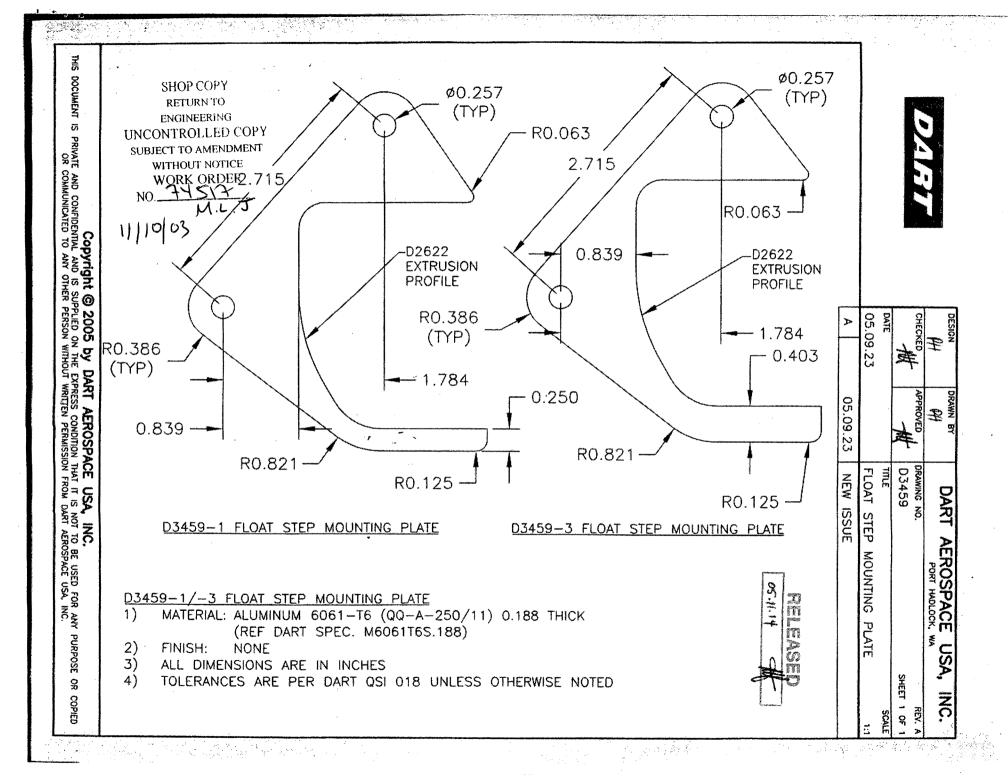
	FIRST A	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	x	First Artic	:le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
Ø0.257	+0.006/-0.001	.258	2		V		
2.715	+/-0.010	2.712	2		V		
0.250	+/-0.010	. સહ્ય	7		V		
R0.125	+/-0.010	761,	7		RC.		
R0.063	+/-0.010	.α3	×		Ribi		
0.839	+/-0.010	. 841	h		V		
0.188	+/-0.010	(88),	8		V		
				_			
						_	
, , , , ,	,				·		
		*					
						· · · · · · · · · · · · · · · · · · ·	
		<u> </u>					
			·		·	Т	
Measured by: 1	B	Audited by:	Na/		Prototype Ap	proval:	N/A

Measured by:	Audited by:	Mal	Prototype Approval:	N/A	
Date: \(\(- \)	Date:	11:11-02	Date:	N/A	

Rev	Date	Change	Revised by	Approved
Α	07.09.26	New Issue	KJ/EC/DD	- 62

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE By Date C								
Part No	:	PAR #:	Fault Categ	ory: N	CR: Yes	No DQ	A :	_ Date: _			
	Re	solution:	Disposition	: G	A: N/C CI	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORMANC	E (NCF	R)		,	, , , , , , , , , , , , , , , , , , ,		
DATE	STEP	Description of NC	Description of NC Corrective Action			Verifi	cation	Approval	Approval		
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector		
	1 1		i i						ļ.		



Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGES	3		***************************************		
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								- '	
·									
Part No:		PAR #:	Fault Cat	NCR: Yes No DQA:			_ Date: _		
	R	esolution:	Dispositi	on:	QA: N/C CI	osed:		Date: _	
NCR:		\		DER NON-CONFORMAN	CE (NCF	₹)			
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		Sign 8	Verification Section C		Approval Chief Eng	Approval QC Inspector
		555,151,77	Chief Eng	Chief Eng	Date	00011		Office Eng	are hispector
						i i			